

Date: Friday, 29/09/2006 9:12:34 AM  
 User: Linda Lacelle

## Process Sheet

Split / 06.10.13







Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 28778-1  
 Estimate Number : 10530  
 P.O. Number : N/A  
 This Issue : 29/09/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : MACHINED PARTS  
 Previous Run : 28444  
 Written By :  
 Checked & Approved By :  
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)  
 Part Number : D2571  
 Drawing Number : D2571 REV E  
 Project Number : N/A  
 Drawing Revision : E  
 Material : N/A  
 Due Date : 06/10/2006 Qty: 6 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B 25354 J.G 06/09/29		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
 		
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 28778 Double check by: J.F. 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. J.F. / J.G 06/09/29		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
 		
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 J.F. 06/10/02		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 28778

Part Number: D2571

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*mk 06/10/02*

*split*  
*6* *PR*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*En 06/10/13*

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*a.m 06/10/13*

*6*

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M101575*

*42 a.m 06/10/13 x 6*

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

*06/10/16* *6*

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*st 345*

*06/10/16* *6*

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*06/10/16* *6*

Job Completion



*c Locel 10/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-10-13	4.0	work order split due to NCR : waiting for engineering approval. split - 1 - 6 saddles on this w/o - 2 - 1 saddle	J	06-10-13	6	U	J 06-10-13

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/12/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

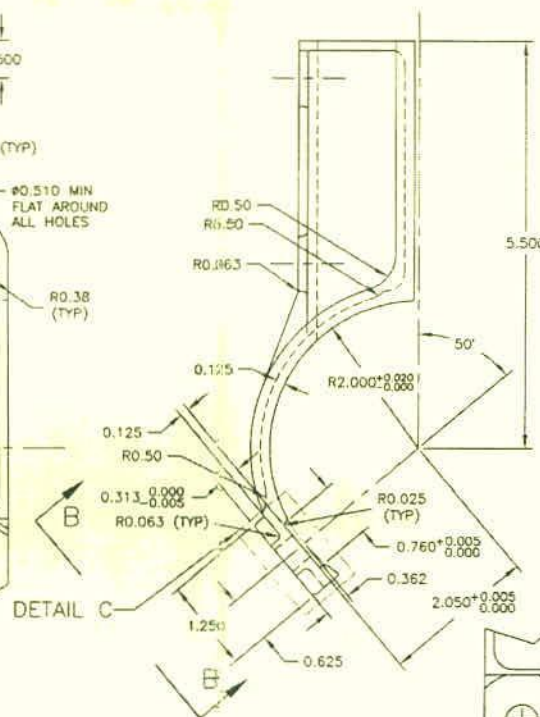
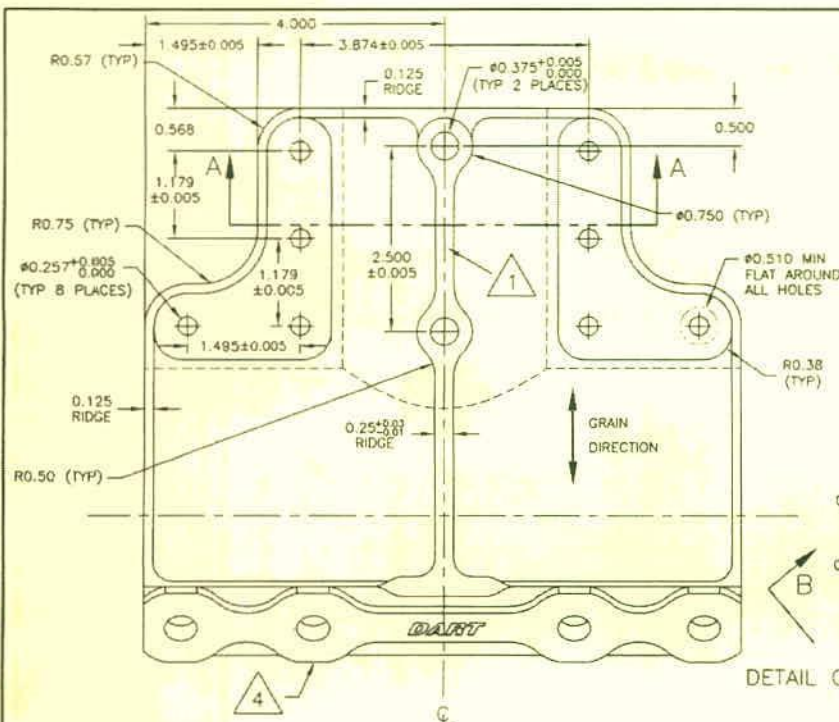
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

05.12.06

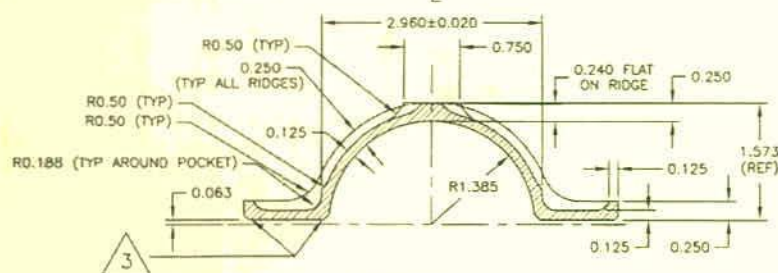


# NOTES

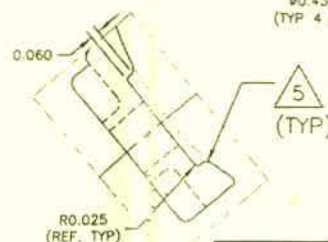
MATERIAL: 7075-T7351 (Q0-A-250/12) (REF DART SPEC. 06102-001)  
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
 QSI 005 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

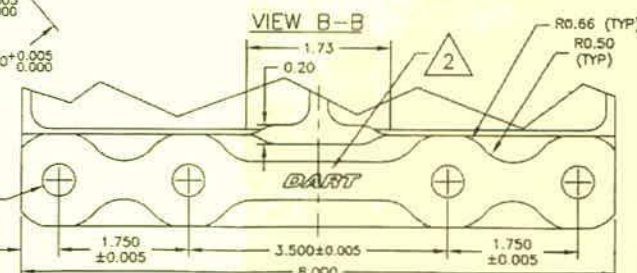
E



SECTION A-A



DETAIL C  
 SCALE 4:3



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2571
		TITLE OUTER FWD SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

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**DART** DART AEROSPACE LTD.  
 HAMMERSBURG, ONTARIO, CANADA

REFERENCE ONLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 25778
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.499	3.499	3.499		
D	1.745	1.755		1.749	1.749	1.750	1.750		
E	7.990	8.010		7.995	7.998	7.999	7.999		
F	0.490	0.510		0.507	0.502	0.502	0.502		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.377	0.376	0.376	0.376		
I	0.490	0.510		0.492	0.500	0.498	0.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.567	0.567	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.873	3.872	3.872	3.872		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.254	0.255	0.253	0.254		
S	0.115	0.135		0.122	0.123	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.966	2.960	2.960		
V	0.230	0.250		0.240	0.236	0.239	0.238		
W	0.115	0.135		0.119	0.122	0.121	0.120		
X	0.308	0.313		0.313	0.311	0.310	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.366	0.364	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.635	0.629	0.630	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.251	0.253		
AE	1.375	1.395		1.388	1.388	1.386	1.387		
AF	0.115	0.135		0.130	0.128	0.128	0.130		
AG	0.240	0.280		0.250	0.250	0.252	0.245		
AH	0.240	0.260		0.250	0.245	0.252	0.251		
AI	2.000	2.020		2.002	2.002	2.001	2.002		
AJ	0.023	0.043		0.035	0.035	0.035	0.035		
Accept/Reject									

Measured by:	mf
Date:	06/10/02

Audited by:	Er
Date:	06/10/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	





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P	0.115	0.135		0.124	0.124				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.253	0.253				
S	0.115	0.135		0.127	0.124				
T	0.178	0.198		0.188	0.188				
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X	0.308	0.313		0.311	0.311				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.363	0.360				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.628	0.628				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.252	0.247				
AE	1.375	1.395		1.385	1.388				
AF	0.115	0.135		0.130	0.125				
AG	0.240	0.280		0.245	0.245				
AH	0.240	0.260		0.252	0.250				
AI	2.000	2.020		2.000	2.002				
AJ	0.023	0.043		0.035	0.035				
Accept/Reject									

Measured by:	mk
Date:	06/10/02

Audited by:	Er
Date:	06/10/13

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